

BLUE

Dart Aerospace Ltd.

Date: Wednesday, 12/11/2008 1:41:02 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TURNING DETAIL FOR D2891-1
<b>Job Number</b> : 43384	
<b>Estimate Number</b> : 13232	
<b>P.O. Number</b> :	<b>Part Number</b> : DSK076
<b>This Issue</b> : 12/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : DSK076 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 42244	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 28/11/2008 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.11.12</u>	
<b>Comment</b> : est rev A. 08.03.13 new issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6104003	Round Billet, 17-4
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Billet

Batch: B343919

RP 08/12/18

SA 08/12/17

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI LATHE

Turn blank for as per Folio FA046

E NOOSAN

RP 08/12/18

SA 08/12/17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

RP 08/12/18

SA 08/12/17

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JL 08/12/18

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

RP 08/12/18 (C)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

08/12/19 JLD

Job Completion



MK 08-12-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	43384
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279						
B	3.702	3.722						
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.041	2.040	2.041	2.040	2.040
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		.923	.923	.923	.923	.923
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110						
L								
M								
N								
O								
P								

Measured by:	SA / RP	Date:	08/12/17
Audited by:	JK	Date:	08/12/18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

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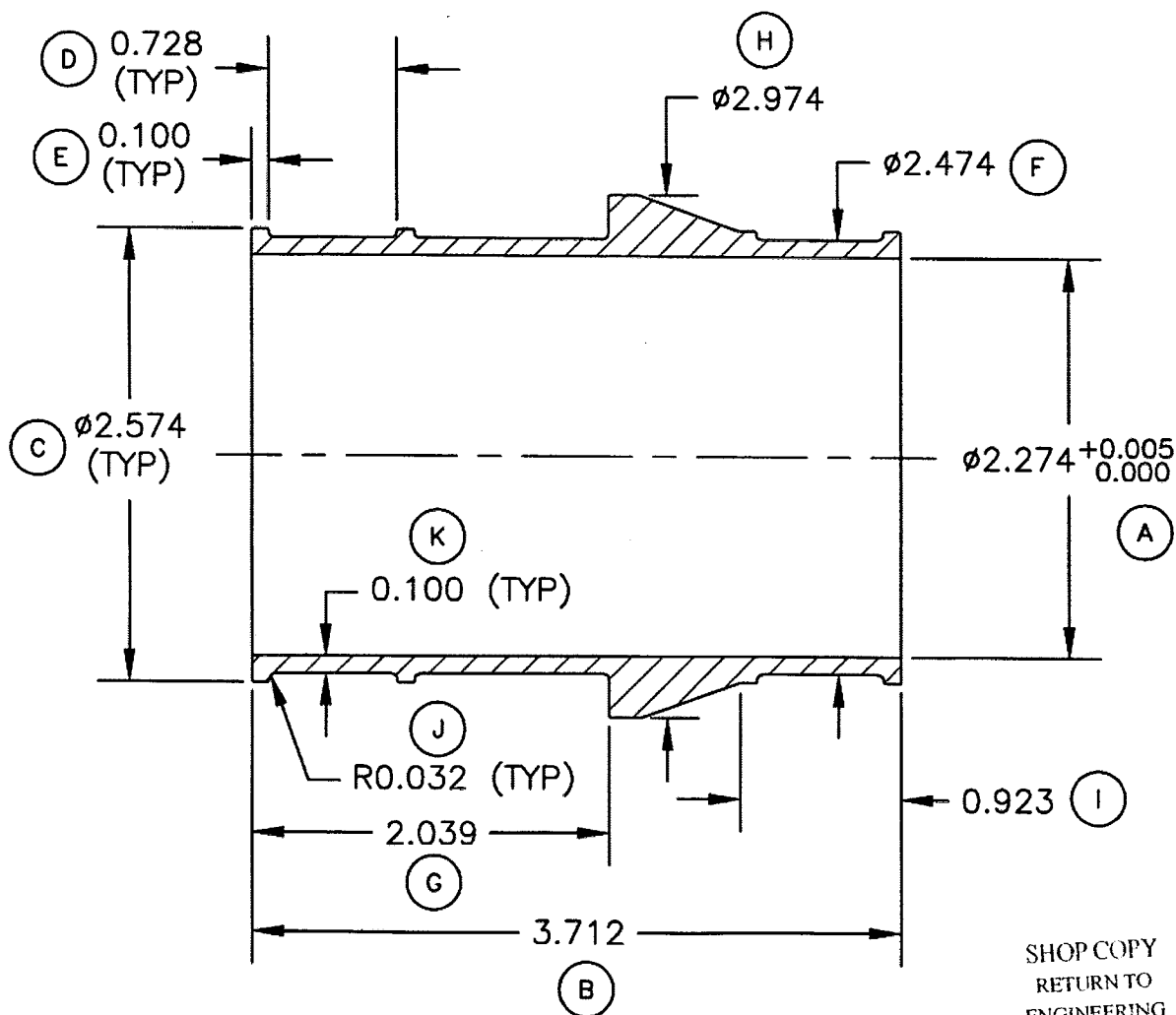
Measured by:	SA / RP	Date:	08/12/17
Audited by:	SL	Date:	08/12/18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01 [Signature]



D2891-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43384

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